

Date: Monday, 04/05/2009 1:45:10 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL TUNNEL L/H
Job Number : 47672A	
Estimate Number : 13585	
P.O. Number :	Part Number : D38221 GY
This Issue : 04/05/2009 S.O. No. :	Drawing Number : D3822-1
Prsht Rev. : NC	Project Number :
First Issue : / / Type : THERMOFORMING	Drawing Revision : B
Previous Run : 47304A	Material : MKYD6185S080P362015
Written By :	Due Date : 11/05/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLO 09.05.06</u>	29
Comment : Est. A New Issue 08/09/17 DL Rev. B Dwg. Update 09/02/09 DL verified by:DD	

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P352068	6185 Kydex .080 steel grey
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Handwritten: 09/05/25



Comment: Qty.: 7.4028 sf(s)/Unit Total : 7.4028 sf(s)
6185 Kydex .080"

M 111807

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/05/20

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/05/20 (x2)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-1 and folio (FTA 025) using tool DT 9073

Dwg. Rev. B
Folio Rev. B

BB 09/05/20 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 1:45:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL L/H

Job Number: 47672A

Part Number: D38221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/05/21 (x2)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 09.05.21

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

ML 09.05.21

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

ML 09.05.21

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.05.25 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPR 47672A

POSITIVE RECALL

EFFECTIVE 09.05.20 AUTH ML

RELEASED ML DATE 09/03/25

SS 09/05/26 (x2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26 (x2)

Job Completion



ML 09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	47672A
Description:	Part Number:	D3822-1
Inspection Dwg: D38221 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u> </u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

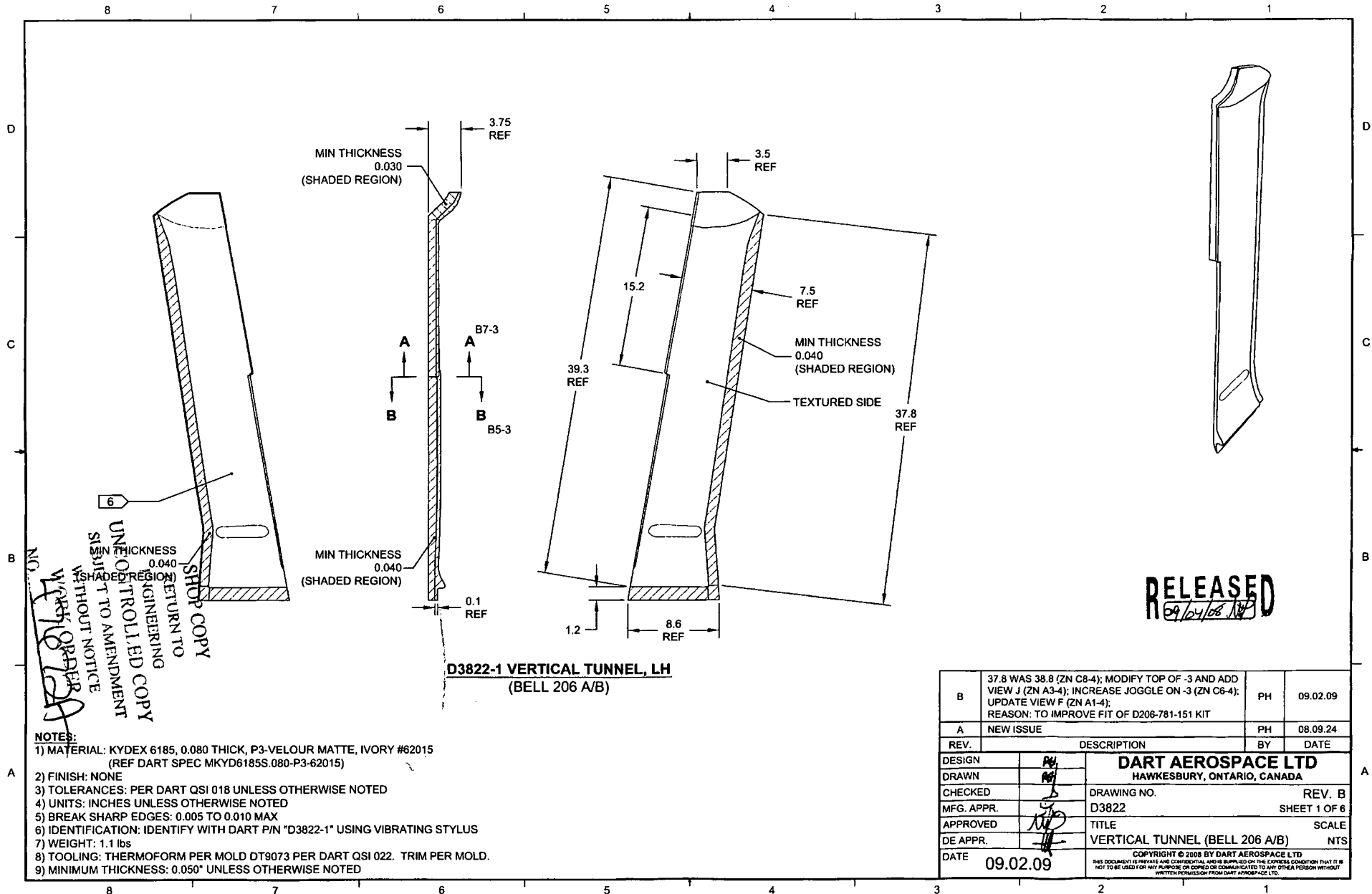
Measured by: <u>BB</u>	Date: <u>09/05/21</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	MIN	0.893	✓			
0.55	MIN	0.68	✓			
0.3	MIN	0.385	✓			
0.030	± MIN	0.035	✓			
0.040	± MIN	0.058	✓			
1.2"	± .100	1.183	✓			

Measured by: <u>Wh.</u>	Date: <u>09.05.21</u>
Audited by: <u>[Signature]</u>	Date: <u>09.05.25</u>
Prototype Approval: <u>[Signature]</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

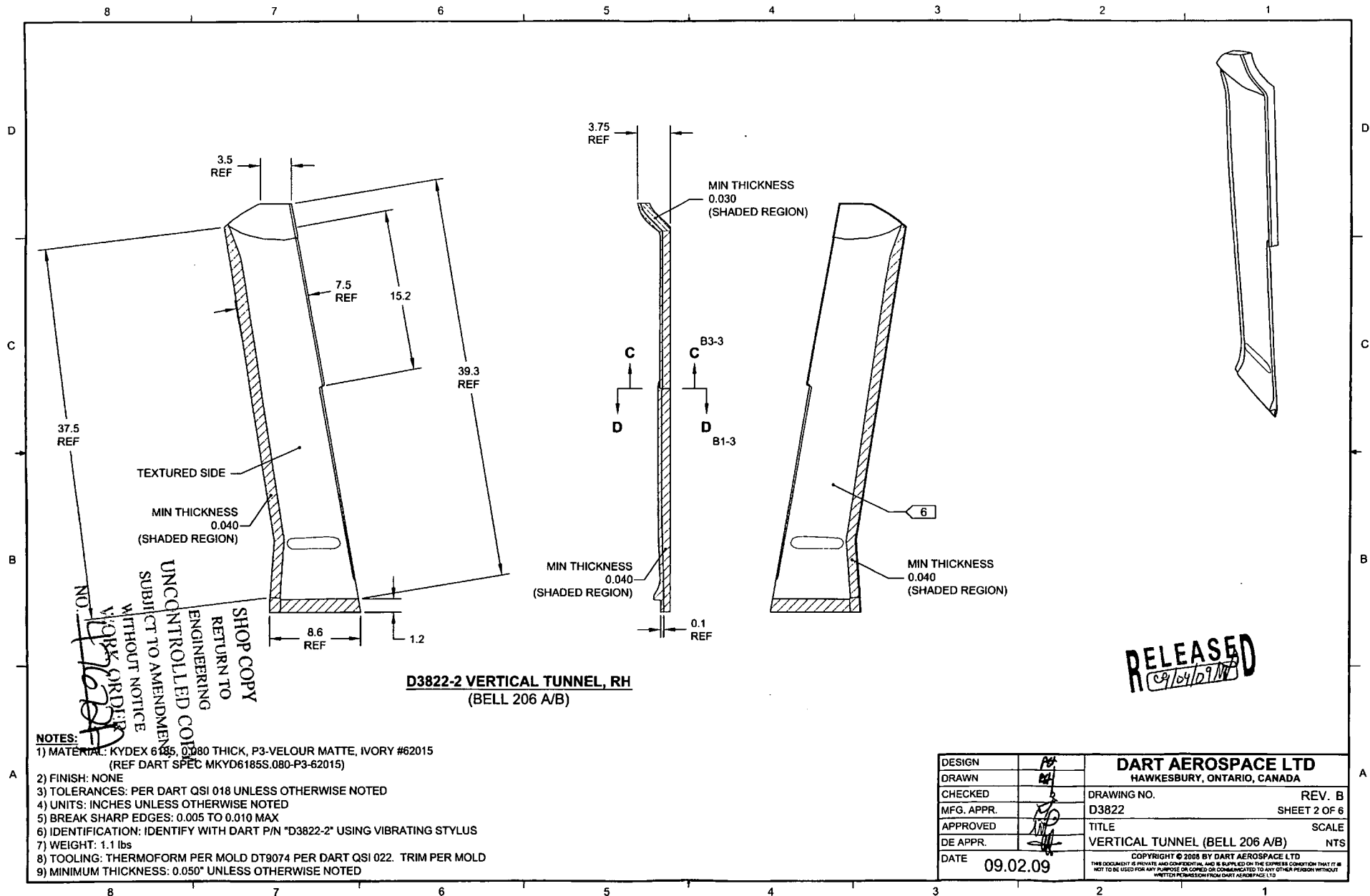


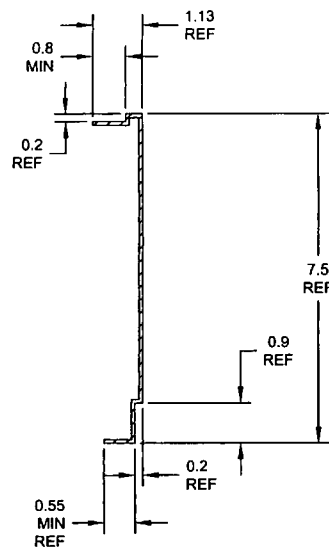
B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C8-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

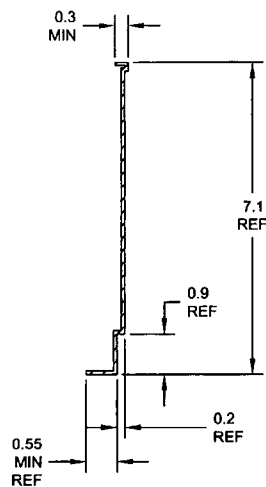
DRAWING NO. REV. B
D3822 SHEET 1 OF 6
TITLE SCALE
VERTICAL TUNNEL (BELL 206 A/B) NTS

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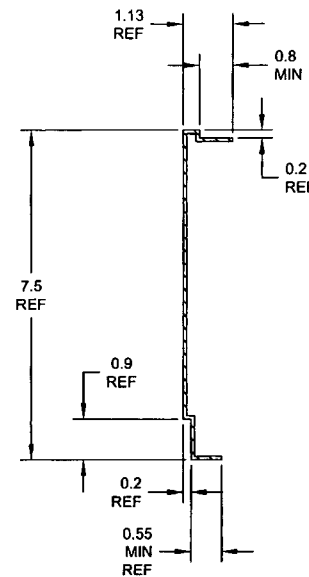




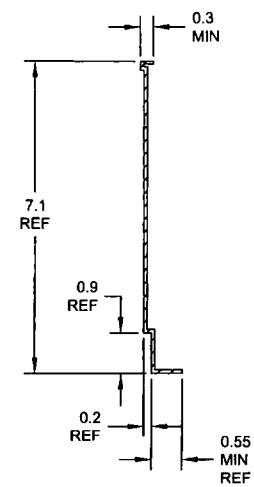
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 446201

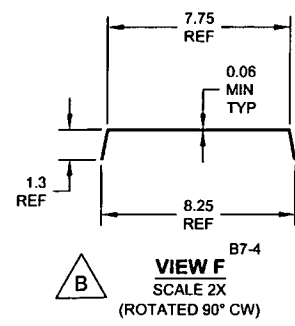
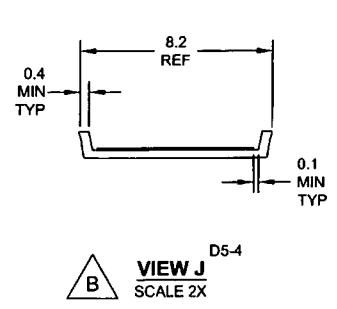
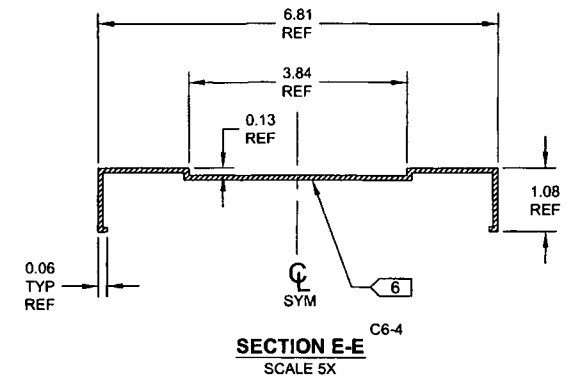
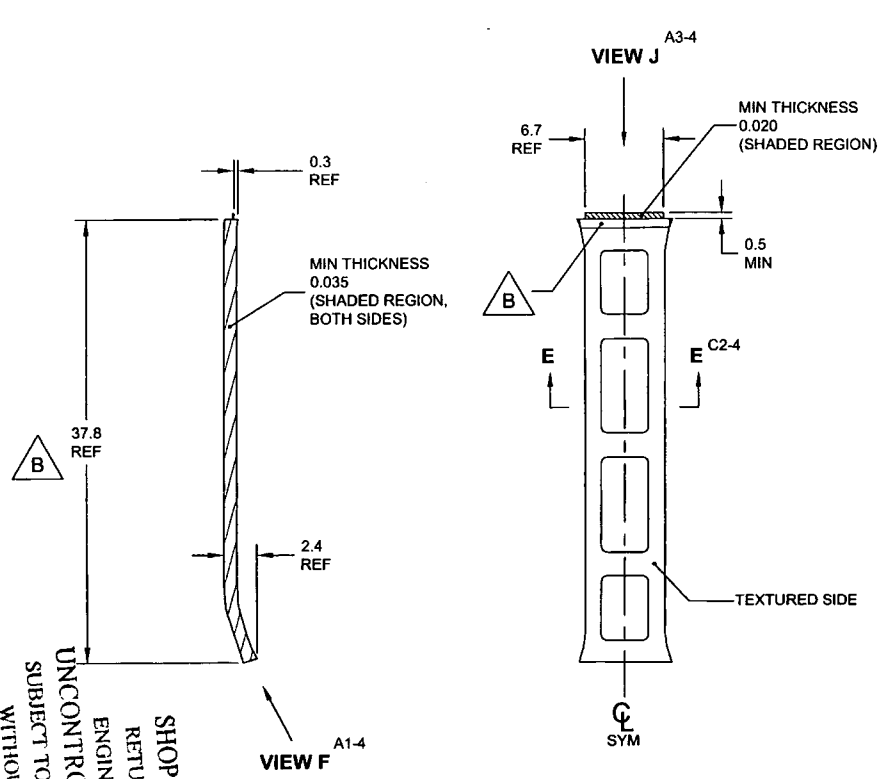
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CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3822	SHEET 3 OF 6
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8 7 6 5 4 3 2 1

D
C
B
A

D
C
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A



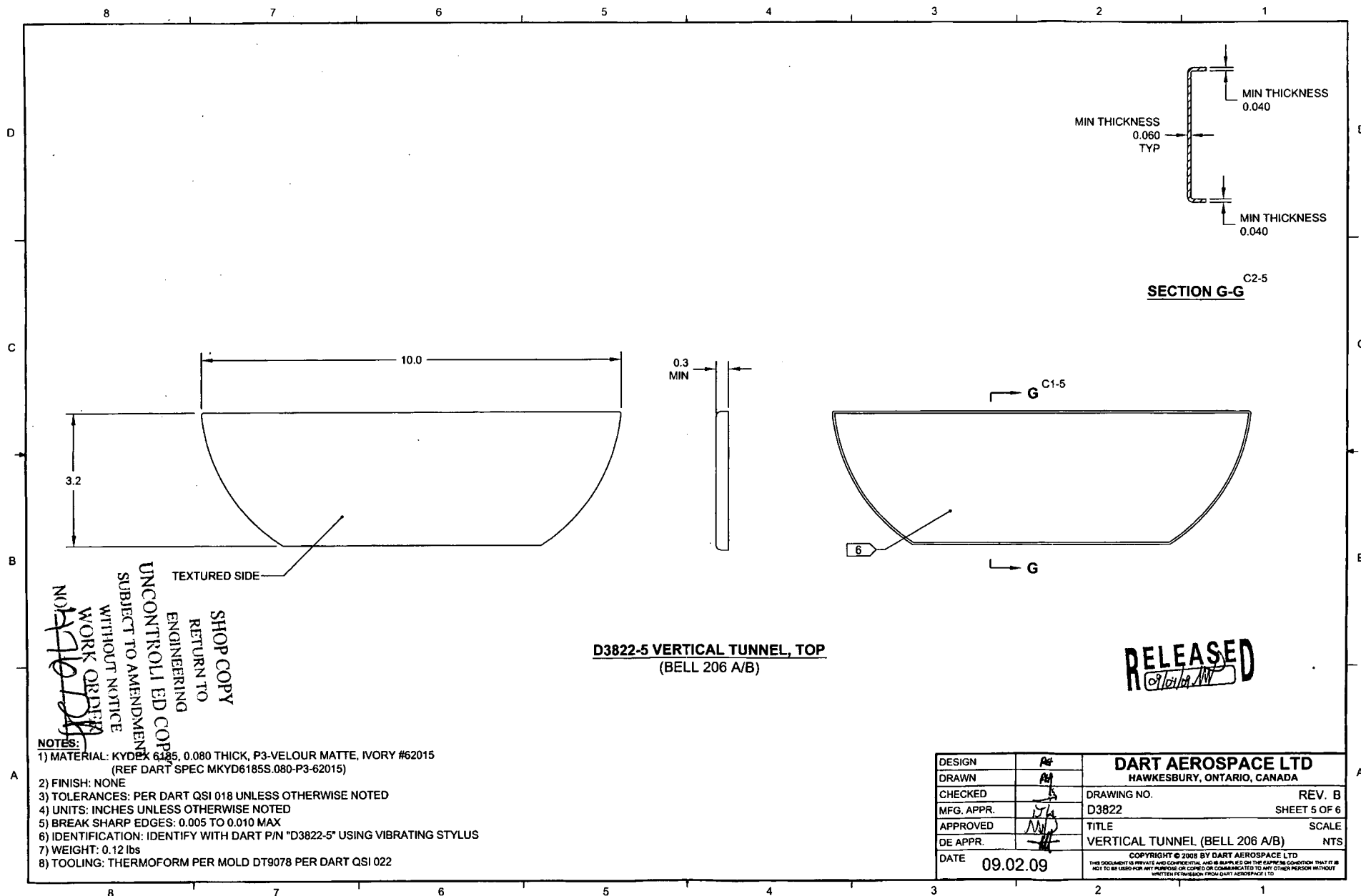
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3/24/09

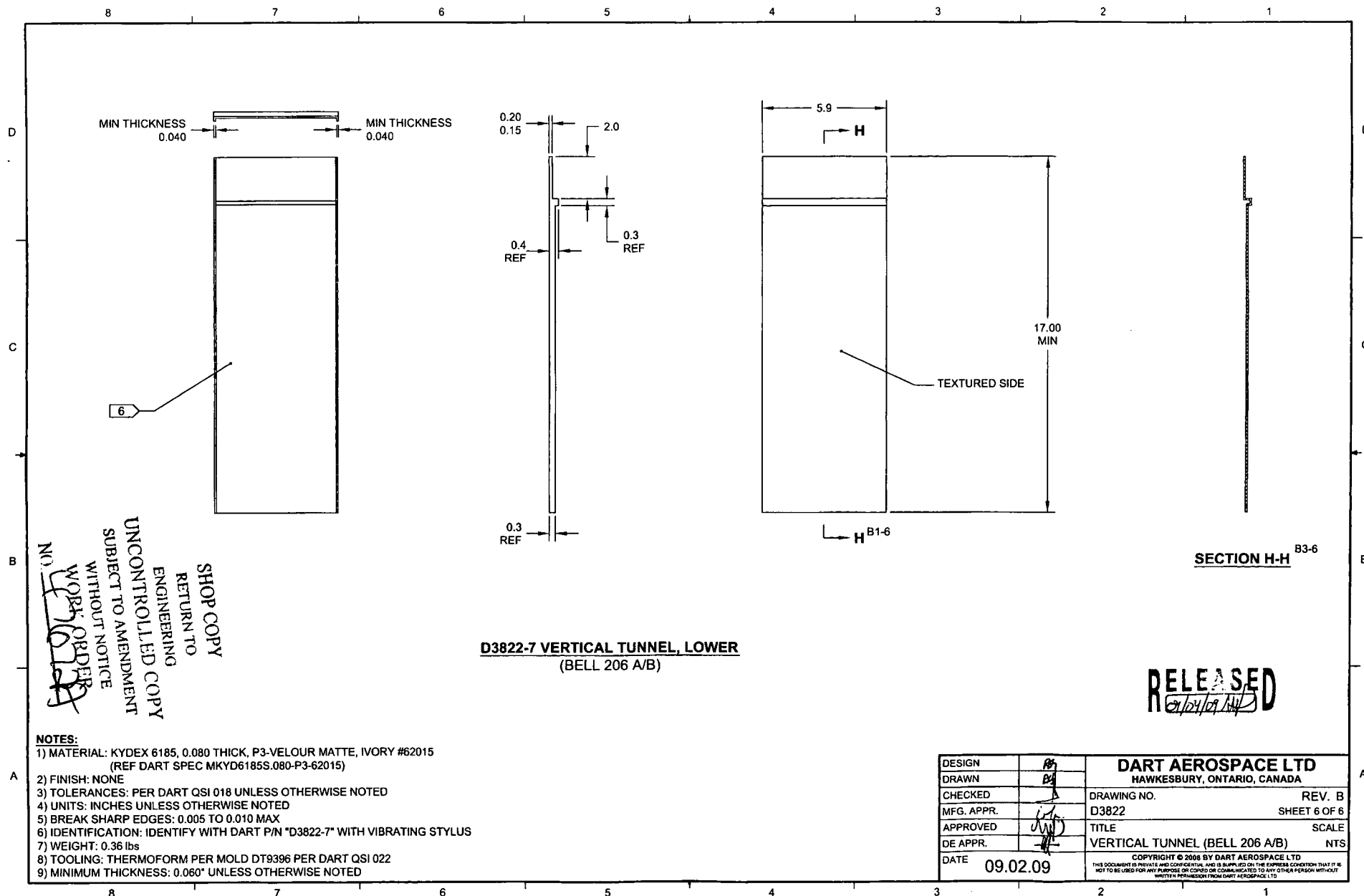
D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

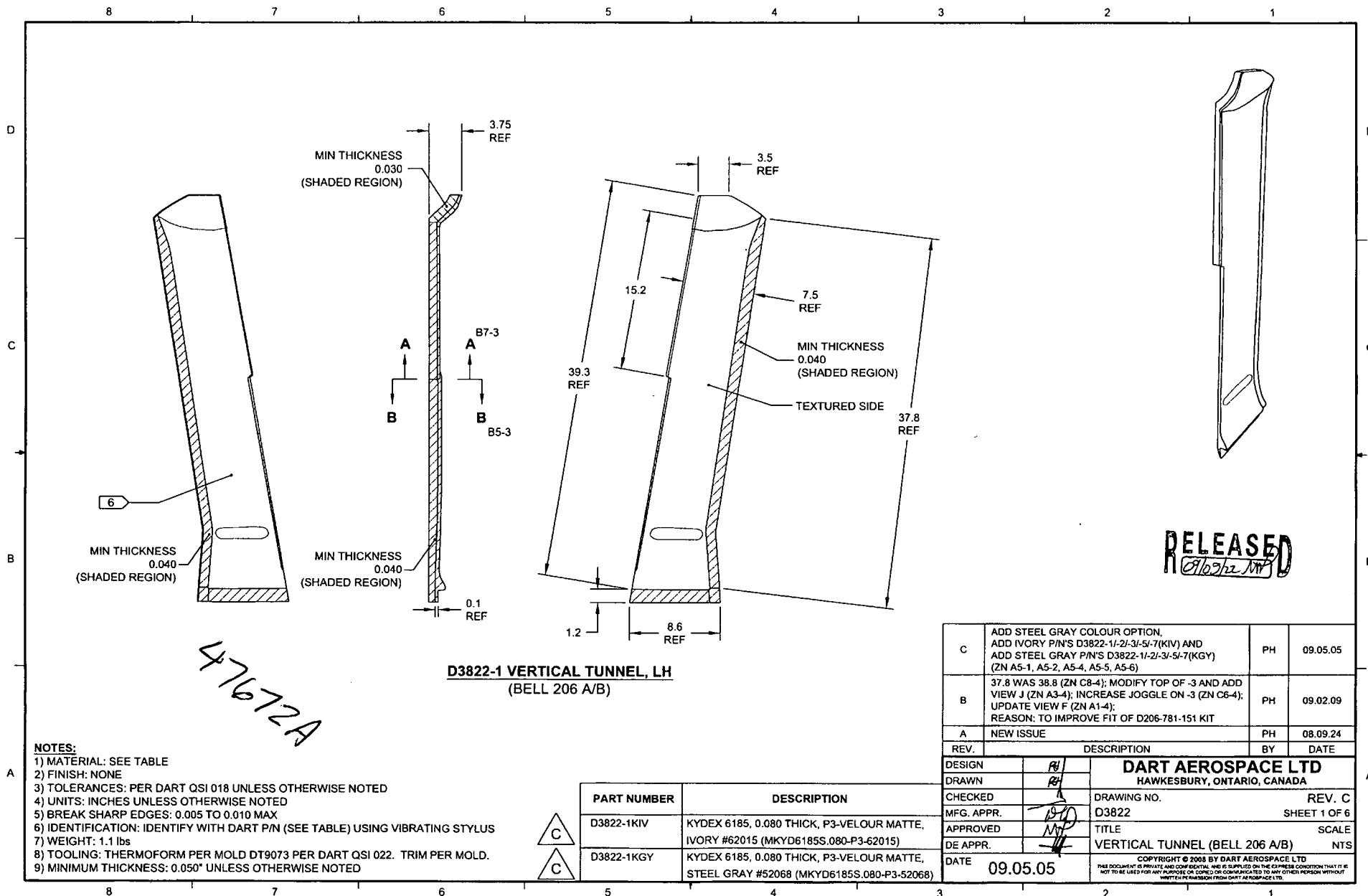
- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 1.1 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD.
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

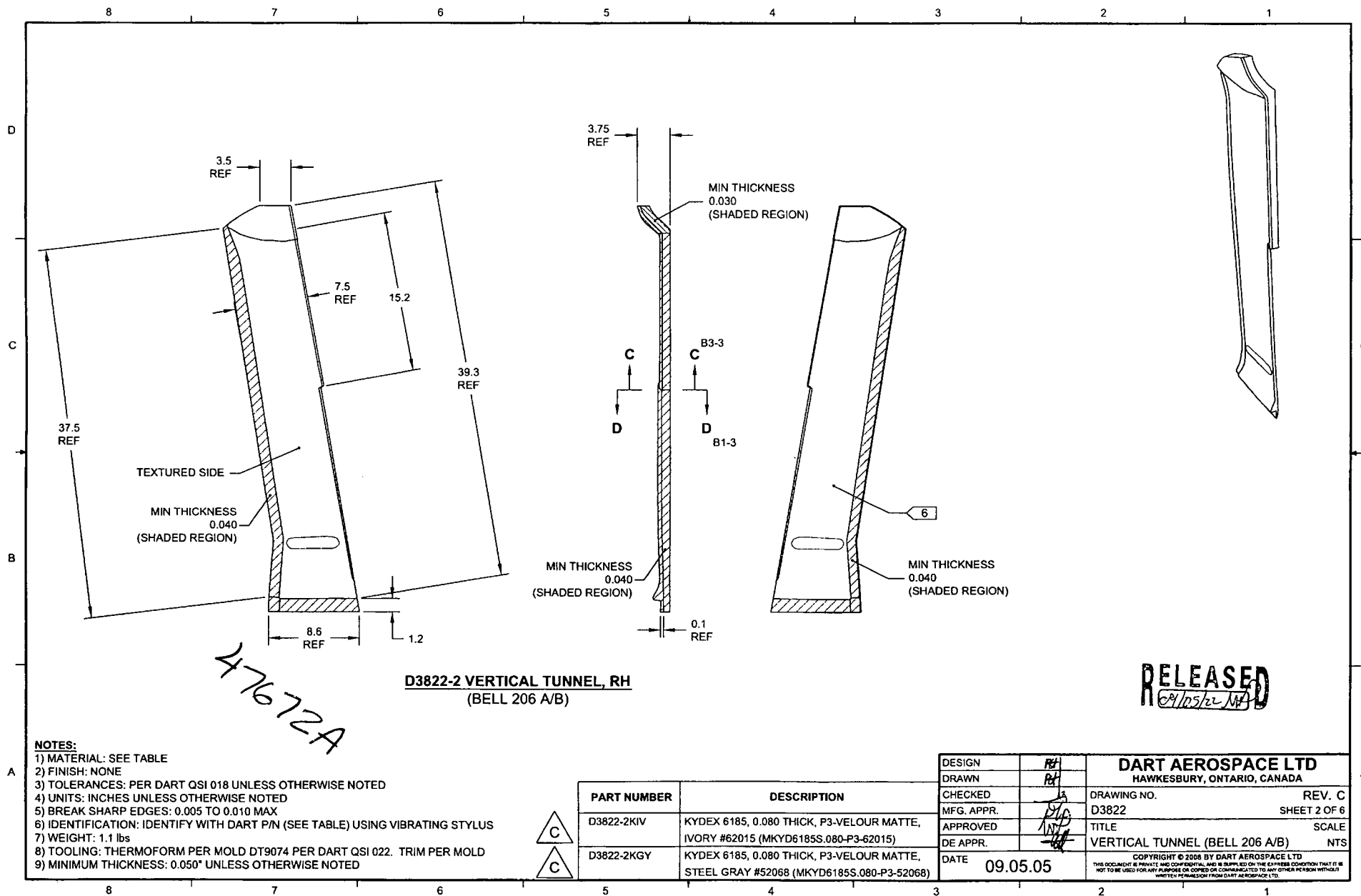
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DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3822	SHEET 4 OF 6
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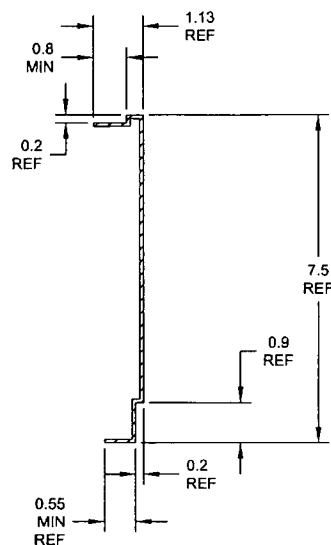
8 7 6 5 4 3 2 1





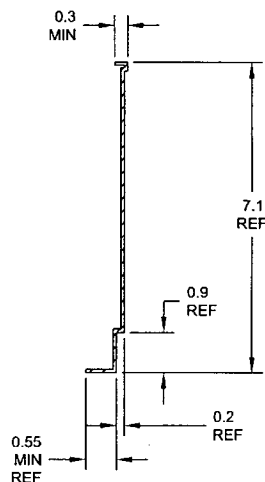






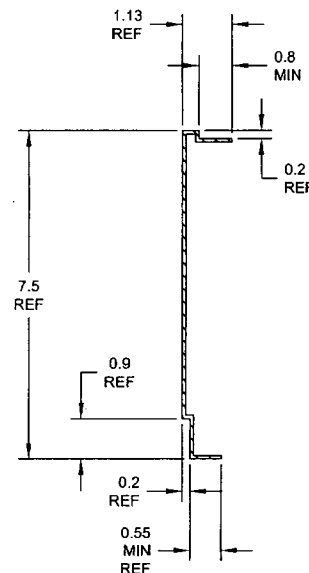
SECTION A-A

C6-1



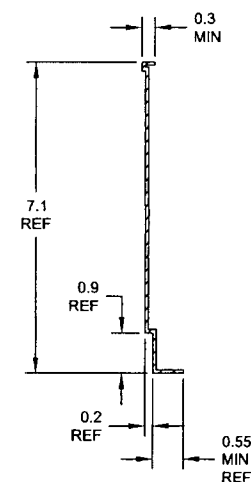
SECTION B-B

C6-1



SECTION C-C

C4-2



SECTION D-D

C4-2

47672A

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09/05/05

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CHECKED	RE	DRAWING NO.	REV. C
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